

Work Order ID 53080

October 22, 2009 3:49:12 PM



Page 1

Item ID: D3186-3

Accept



Setup Start



Revision ID: E

Stop



Item Name: Spacepod Door, LH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: PL

Date: 09-10-22 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3186

Rev E

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)

ET 10-04-13

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Siobachiz



120

Identify as per dwg & Stock Location: composites

0.00



Packaging

Memo

0.00

Packaging

ET 10-04-13

Work Order ID 53080

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Page 2

Item ID: D3186-3

Accept



Setup Start



Revision ID: E

Stop



Item Name: Spacepod Door, LH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/21 *[Signature]*
MF
10-4-21

Picklist Print

October 22, 2009 3:49:16 PM

Page 1
1

Work Order ID: 53080



Parent Item: D3186-3RevE



Parent Item Name: Spacepod Door, LH


Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

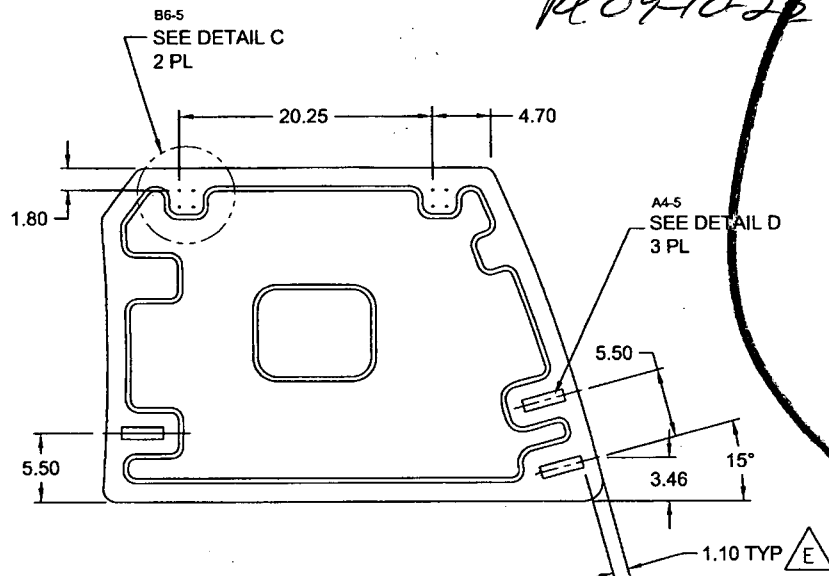
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3186-1MRevE		Manufactured	No				Each	0.0000	1.0000			
												
SPACEPOD DOOR LH												

B 53188



RT 10-04-13

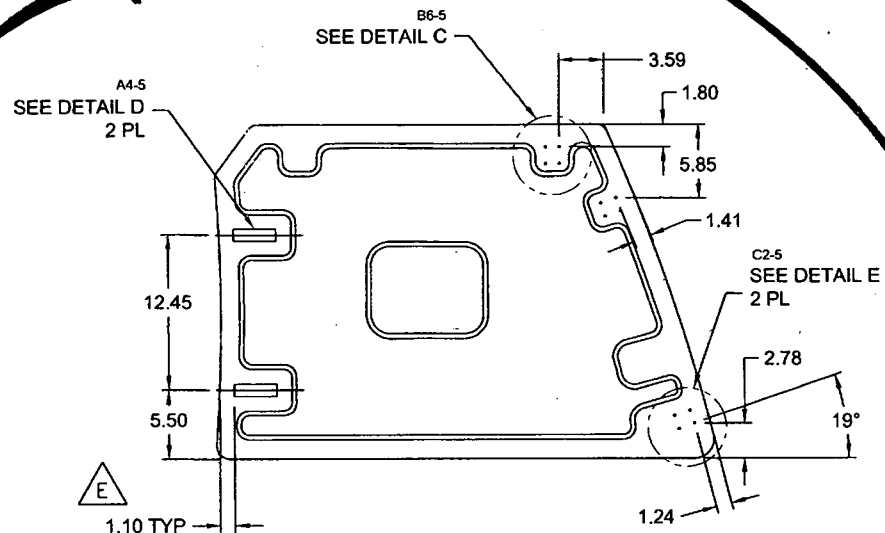
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AGREEMENT
WITH THE CUSTOMER
WORK ORDER
NO. 53080
R09-10-22



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

NOTES:

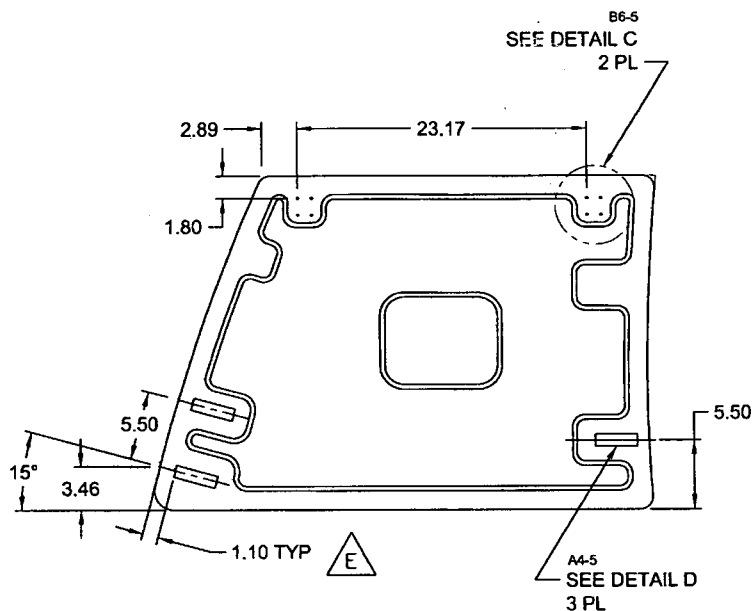
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



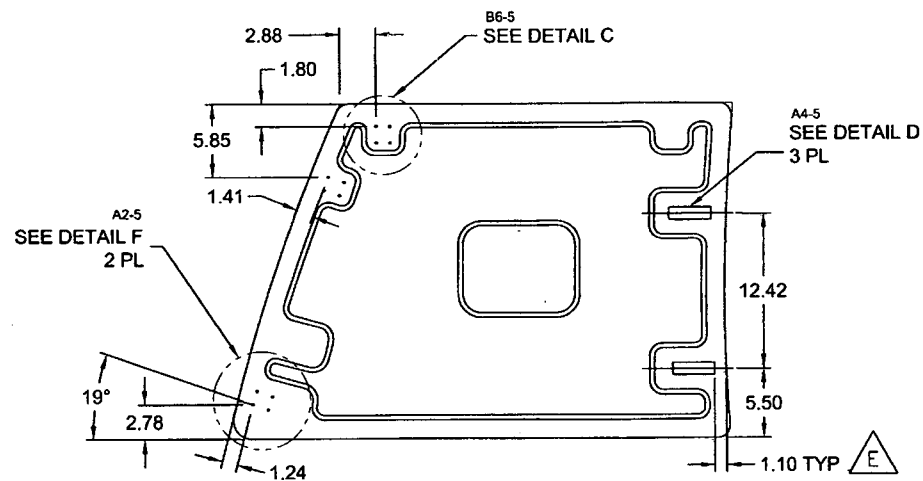
D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2009-09-09

REV.	DESCRIPTION	BY	DATE
E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M



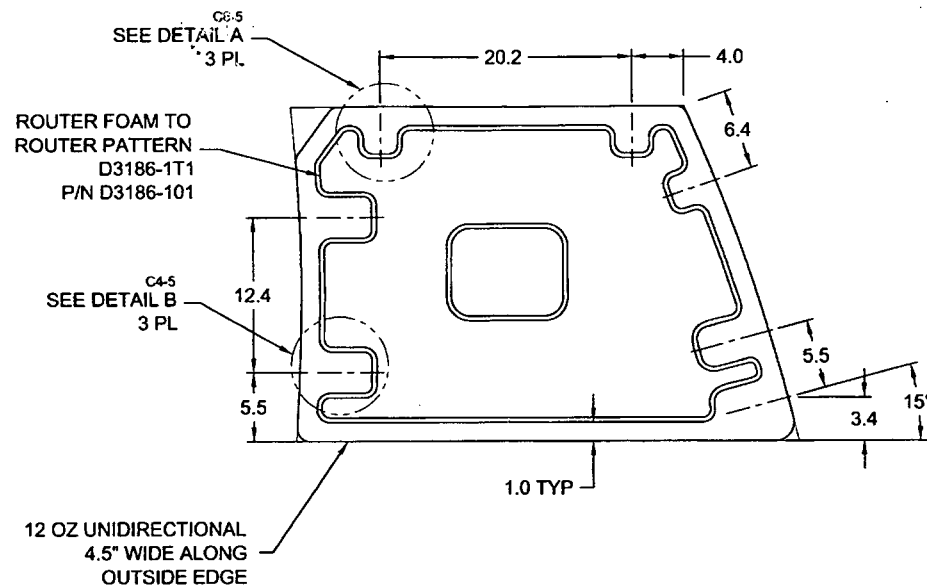
D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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2009-09-09

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D3186-1M SPACEPOD DOOR AS MOLDED

NOTES:

1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 LAMINATE PER DART QSI 006 4.0
 LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8005 FOR DOOR LAYUP

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)

9 OZ SATIN (9 SQ FEET)

FOAM

9 OZ SATIN (9 SQ FEET)

12 OZ UNIDIRECTIONAL

9 OZ SATIN (9 SQ FEET)

RESIN (35-45% BY WEIGHT)

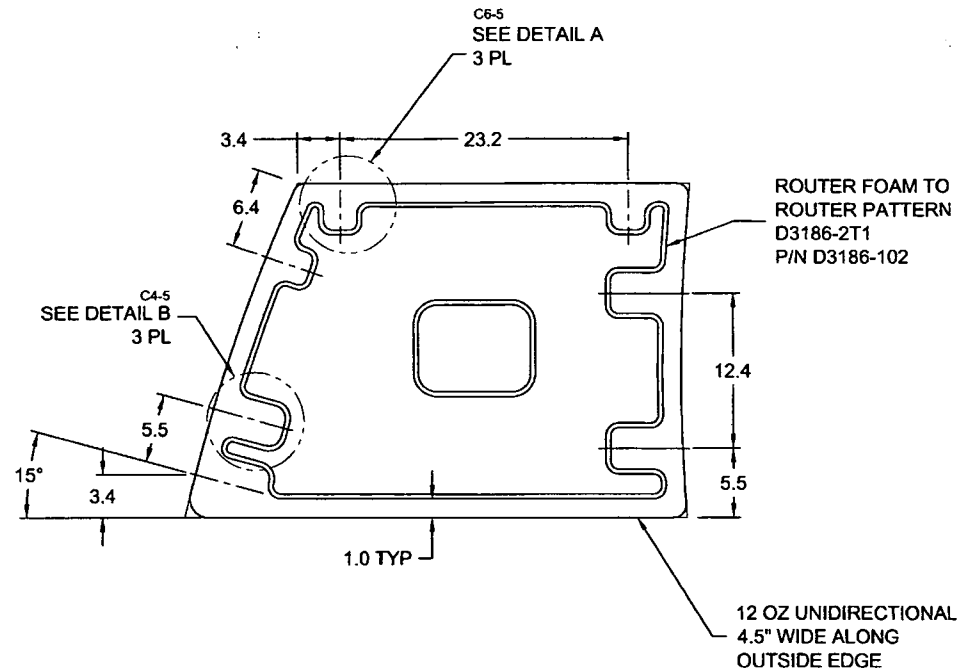
PEEL PLY

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DE APPR.		SPACEPOD DOOR	NTS
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MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY



NOTES:

1) MATERIAL:

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 LAMINATE PER DART QSI 006 4.0
 LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

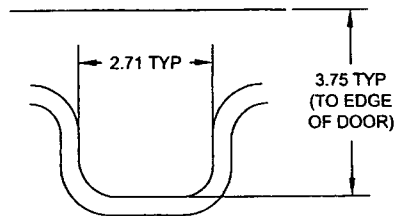
8) USE MOLD DT8006 FOR DOOR LAYUP

D3186-2M SPACEPOD DOOR AS MOLDED

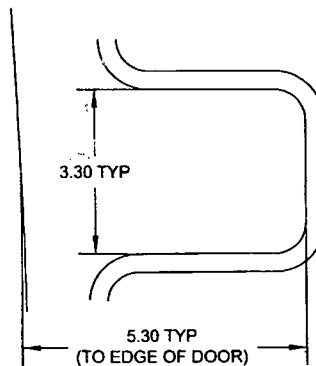
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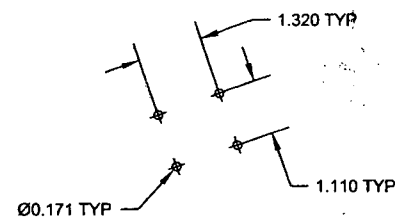
53080



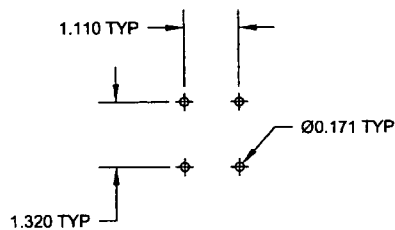
DETAIL A D6-3
SCALE 4X D4-4



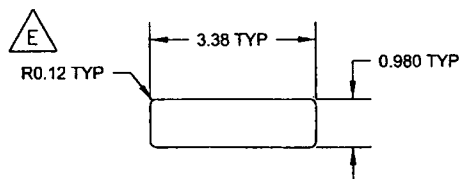
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

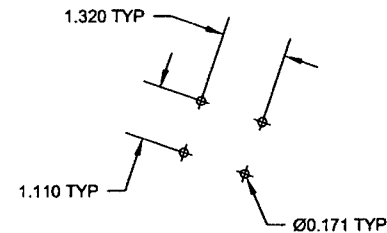


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2






NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2



DETAIL F C4-2
SCALE 4X

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2009-09-09

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